

Work Order ID 131312

Thursday, April 02, 2015 11:49:17 AM

131312

Page 1

Item ID: D119-796-201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step

Start Date: 4/2/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/2/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-04-02 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-796	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D119-796-201 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
68
9-89

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46
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APR 08 2015

(IX)

DAS
68
9-89

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(IX)

DAS
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9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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131312

Page 2

Item ID: D119-796-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: AFT Crosstube Installation with Step

Stop ***NS2***Start Date: 4/2/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/2/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-201 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Ship

ME
15-4-8

MCJ 1504-08

ME
15-4-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 131312

131312

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 4/2/2015

Required Date: 4/2/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM
REV:B 14.10.22 AS PER PA1 DD VERF:JLM
14.11.19 AS PER IIN REV.B DD VERF:JLM
AS PER REV C JLM VERIFIED BY:DD

IPP
IPP REV:C
IPP REV D 15.02.13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-251		Manufactured	No				Each	0.0000		1			
D119-796-251		DAS 46						DAS 06 9-89	**			DAS 06 9-89	
Aft Crosstube, STD w/ Peg Steps (MKII)		9-89											
MS21250-05-048		Purchased	No				Each	39.0000		4			
MS21250-05-048		DAS 46							**				
BOLT		9-89											
				<u>Location</u>				<u>Loc Qty</u>					
				ST298				39					
				m131559				9		4			
				m131605				30					
AN5C32A		Purchased	No				Each	149.0000		4			
AN5C32A		DAS 46							**				
BOLT		9-89											
				<u>Location</u>				<u>Loc Qty</u>					
				FG				4				DAS 06 9-89	
				18918				4					
				ST286A				100					
				131650				100					
				ST336				45					
				m130298				3		3			
				m131152				42		1			

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Work Order ID: 131312

131312

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 4/2/2015

Required Date: 4/2/2015

Start Qty: 1.00

Required Qty: 1.00

AN5C7A

Purchased

No

Each

229.0000

12

AN5C7A

DAS

46

BOLT

9-89

DAS

66

9-89

Location

Loc Qty

Loc Code

FG

2

19185

2

ST286A

150

m131320

150

ST338

77

19185

1

m131139

76

Each

150.0000

4

MS21043-5

Purchased

No

MS21043-5

DAS

46

Nut

9-89

DAS

66

9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

81

116548

81

ST304

49

m131317

49

Each

791.0000

20

NAS1149C0563R

Purchased

No

NAS1149C0563R

DAS

46

Washer

9-89

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Location

Loc Qty

Loc Code

ST260a

500

m131697

500

ST271

291

m131026

291

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : ☐																																																															

REFERENCE ONLY

DART AEROSPACE LTD.

DAS

IIN-D119-796

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5.0 PARTS LIST

APR 08 2015

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2						1			D5122-1	CENTER SUPPORT
3						6			D5123-1	CLAMP CUSHION
4					4		4	4	D5123-3	CLAMP CUSHION
5						2			D5123-5	CLAMP CUSHION
6					2				D5124-1	FWD SUPPORT
7						1			D5134-041	DAMPER SUPPORT ASSY, LH
8						1			D5134-042	DAMPER SUPPORT ASSY, RH
9						1			D5136-1	CONTACT PAD, LH
10						1			D5136-2	CONTACT PAD, RH
11							2		D5149-041	FWD STEP ASSY
12								2	D5149-043	AFT STEP ASSY
13					2				D5152-041	FWD POST MOUNT ASSY
14						2			D5152-043	AFT POST MOUNT ASSY
15							4		MS21920-22	CLAMP
16					4				MS21920-24	CLAMP
17						6		4	MS21920-25	CLAMP
18						2			MS21920-28	CLAMP
19	4	4	4	4					AN5C32A	BOLT
20	4	4	4	4					MS21250-05048	BOLT
21	12	12	12	12					AN5C7A	BOLT
22	4	4	4	4					MS21043-5	NUT
23	20	20	20	20					NAS1149C0563R	WASHER

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Revision: C
Date: 14.12.22